Work Order ID 105294 *105294* Page 1 August-01-13 11:22:40 AM Accept D3262-041 *N900040100* Setup Start Item ID: **Revision ID:** Canister Assembly Item Name: Start Qty: 1.00 8/01/13 **Cust Item ID: Start Date:** Req'd Qty: 1.00 Required Date: 8/01/13 **Customer:** Reference: Run Process Plan: MLJ Date: 13-08-01 Tooling: Date: **Approvals:** QC: Date: SPC (Y/N): Date: Reject Tool ID Tool # Plan Accept Reject Insp. Sequence ID/ Operation Set Up/ Number Stamp Work Center ID Description **Run Hours** Code Qty Qty **Revision Nbr** Draw Nbr Rev E D3262 Weld per dwg A/R Aluminum rod Batch: MDL395 0.00 D 13-09-26 09 Large Fab *100* 0.00 Large Fab Memo Weld canister assembly as per Dwg D3262 using DT8739 to align fillings Large Fab OC9- Inspect visual per QSI004- Fusion Welds 110 *110* 0.00 Memo Quality Control QC5- Inspect part completeness to step on W/O 120 *120* QC Memo ** Pressure test as per Dwg D3262 Quality Control

. •

NCR: Y	es/	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	ATE			
		•							-		QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No				Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Pro Rec/Stor	Engineering Quality Other					
Root	_				Descri	ption of work order update	T	Initial	Actio	on ·	Sign &		
Cause	1	Date	Step	Qty		or Non-conformance		nief Eng	Descri		Date	Verification .	QC Inspector
Doc/Data			,	<u> </u>						•		***	
Equip/Tooling													
Operator			į										
Material							1						
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Other						•							
Process							1						
Supplier							ŀ						` .
Training													
Unapproved												١	
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Landi	ng G	ear				General		-			_		•
	-	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Ш	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete	<u></u>	Part Incorred	ct	Weld
	Ш	Crushed/	Crimped			Burrs	L	-	ions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte	nance		Part Moved	•	
		Heat Trea	at		L	Countersink		Mislabe	led	<u></u>	Positioned V	· ·	1
		Inspectio	n Strip in	Tube		Cut Too Short	L	Misread	1	L.	Power Loss/	Surge	Other
	Ш	Ripples in	Bend			Drill Holes	L	Offset					
		Torque W	laves in l	Extrusio	n .	Drawing	1 `	Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish .

Work Ord	,	5294		*105	5294*						Page 2
Item ID: Revision ID: Item Name: Start Date:	D3262-041 Canister Asse 8/01/13	mbly Start Qty: 1.00	*1*	Accept	*N900		100)* s	etup Star	IVI	S1* S2*
Required Date:		Req'd Qty: 1.00	*1*		Cust mem	שו:					
Reference:	,										•
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:		R	un Star	17	R1*
• •	QC:		Date:	SPC (Y/N):	D	ate:			Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description Chemical Conversion Co	oat per QSI005 4.1	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
HandFinish Hand Finishing		Memo		0.00							
140 *140* Powdercoat Powder Coating	125	START TIM	to mask threads **** /E: //PERATURE:	0.00 2007				1 X y	8m)	L131	04/30
*150		QC3- Inspect Part Finish	3~3	0.00				-1-1-	-£	<u>jl</u> j	13/0d/s
QC		Memo		0.00				(~	. 4	•	

Quality Control

										DQA:	Date.	
NCR: Y	es / No				WORK ORDER NON-C	100	NFORM	/ANCE / UPD	ATE	QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE			
Part No. NCR No.					Scrap Machining Sma Use-as-is Thermoforming Fin		Crosstube Small Fab Finishing Composite	Pro Rec/Stor	Engineering Quality Other			
Root				Descri	tion of work order update	П	Initial	Actio	on	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descrip	ption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator [
Material [
Setup						İ	1					
Other							1					
Process		ļ						İ				
Supplier								İ				
Training								İ				
Unapproved		<u> </u>						<u> </u>				<u> </u>
					-	AUL	T CATE	3ORY				
Landir	ng Gear				General	_	1 .			1	г—	.
	Bending				Bend	<u></u>	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (^{O/S}	BOM/Route	-	Hardwa		<u> </u>	Over/Under	-	Temperature/Cure
1	Cracks				Broken/Damaged		-} '	on incomplete	<u> </u>	Part Incorred		Weld
	Crushed/	Crimped		<u> </u>	Burrs	<u> </u>	4	ions Incomplete/Ur	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	\vdash	Mainte		ļ	Part Moved	.,	
	Heat Trea			\vdash	Countersink	\vdash	Mislabe		<u> </u>	Positioned V		7
. , ,	Inspectio	-	Tube	<u> </u>	Cut Too Short	\vdash	Misread			Power Loss/	Surge	Other
	Ripples in	n Bend		<u> </u>	Drill Holes	<u></u>	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

August-01-13 1		<i></i>		*105	1794"							Page 3	
Item ID: Revision ID:	D3262-041	,		Accept	*N900	040	100)* s	etup	Start		S1*	
Item Name:	Canister Asse	mbly								Stop	*N	S2*	
Start Date:	8/01/13	Start Qty: 1.00	*1*		Cust Item I	D:							
Required Date:	8/01/13	Req'd Qty: 1.00	*1*		Customer:								
Reference:								ID	Run	Start	-J- N 1	— 4 sk	
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:	^* ****	N	·uii		×Ν	R1*	
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description	rd (, c ,	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
160		Identify as per dwg & St	ock Location: 57488	0.00				16	2	10 1	19	940 32	
160 Packaging		Memo		0.00				_/\	· —	13/	9/0 (2,69	
Packaging													
								m /	/				
170		QC21- Final Inspection	- Work Order Release	0.00				1/	Dr.	n 13	/10/0	1	
170		Memo		0.00			_	7) <i>[</i>					
Quality Control								<i>O</i> ,				~	0
										.41 -	$5 l^{\frac{3}{2}}$	3-10-	
										NIO			

NCR:	Yes	1	No
INCh.	162	/	INU

									DQA:	Date:	:	
NCR: Ye	es / No			WORK ORDER NON-	CON	FORM	MANCE / UP	DATE	QA Closed:	Date:		•
Manla Ondon	<u>.</u>			DISPOSITION				AGAINST DE			·	
Vork Order Part No NCR No	D			Rework Scrap Use-as-is Work Order Update		N Therm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root Cause	Date	Step	Qty	iption of work order update or Non-conformance		itial ef Eng		ction cription	Sign & Date	Verification	QC Inspector	
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved												
				F	FAULT	CATEG	ORY		1			
Landin	g Gear	<u></u>	<u> </u>	 General	FAULI	CATEG	ORY			<u></u>		-
	Cracks Crusher Cuffs Heat Tr Inspect Ripples Torque	Not Conce	1 Tube Extrusion	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		nstructi Mainte Mislabel Misread Offset Out of C	on incomplete ons incomplete/ nance	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	

Outside Dimensions

Wave/Twist in Tube

August-01-13 11:22:39 AM

Work Order ID:

105294

Parent Item:

D3262-041

Parent Item Name:

Canister Assembly

Start Date: 8/01/13

Required Date: 8/01/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP C05.03.10Removed P/O for liquid penetrant

inspectionKJ/JLM 571 DD 10.05.10 verified :EC

IPP Rev:D as per ECN10-

	3/1 00 10.03.10	verified .EC											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3262-1 Tube		Manufactured	No			100	Each	0.0000	1	B105	362->(ی کھ	0-09-25 PD
D3262-3 Cap		Manufactured	No			100	Each	0.0000	2	Biolo	<u> </u>	(2)	13-09-25 PD

NCR: Y	es /	' No				WORK ORDER NON-	COI	NFORM	MANCE / UPDA	ATE			*
									·		QA Closed:	Dat	e:
Work Orde	er: _					DISPOSITION				AGAINST DE	PARTMENT,	-	
Part N	No					Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Small Fab Finishing	4	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	No			·		Work Order Update	<u></u>		~ —	Composite		Supplier	
Root					Descri	ption of work order update		Initial	Actio	n	Sign &		
Cause	\perp	Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Descrip	tion	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							1						
Operator													
Material													
Setup		;											
Other	Ш												
Process							1						
Supplier	Щ												
Training													
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					· · · · · · · · · · · · · · · · · · ·		AUI	T CATE	GORY				
Landii					_	General	_	7		_	1	_	 -
		ending				Bend		Grain		<u> </u>	Ovalized	L	Pressure/Forced
	ш		ot Concer	ntric to	o/s	BOM/Route		Hardwa			Over/Under	H	Temperature/Cure
		racks				Broken/Damaged		4 '	on incomplete		Part Incorred	⊢	Weld
	-		Crimped			Burrs		4	ions Incomplete/Un	}	Part Lost/Mi	ssing	Wrong Stock Pulled
		uffs			_	Contamination	_	Mainte		—	Part Moved		
	\vdash	eat Trea			_	Countersink	\vdash	Mislabe			Positioned V		·
	$\boldsymbol{\vdash}$	•	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	⊢—	ipples in				Drill Holes	L.	Offset					
	T	orque W	aves in E	xtrusio	ո [Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

-	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

105294 MLJ 13-0801 -FITTING HOLES IN LINE Ø5.17 REF

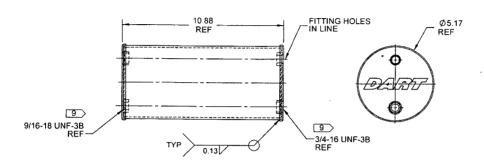
D3262-041 CANISTER ASSEMBLY

NOTES:	
1) MATERIAL: N/A	,
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1	
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3	
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED	
4) UNITS: INCHES UNLESS OTHERWISE NOTED	
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX	
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER	
7) WEIGHT: 2.51 lbs	
8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR	
PRESSURIZE TO 10 nsi AND SURMERGE LINDER WATER TO CHECK FOR LEAKS	

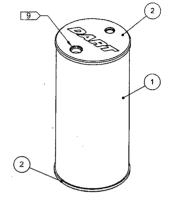
RF	HAWKESBURY, ONTARI		- 1
RF	DART AFROSPA	CET	TD.
0	ESCRIPTION	BY	DATE
NEW ISSUE		RF	04.05.06
ADD PRESSURE TES	STING OPTION	MB	05.02.14
Ø5.165 WAS Ø5.190)	RF	06.08.31
ADD D3262-043/-5 (ZN B TO EQUAL TOOL DIMEN 09-004	5-2; B5-5); REVISE DIMENSIONS ISIONS (ZN B2-4; C2-4) PER CAR	RF	09.12.30
		RF	10.05.03
	ADD D3262-043/-5 (ZN B TO EQUAL TOOL DIMEN 09-004 Ø5.165 WAS Ø5.190 ADD PRESSURE TES NEW ISSUE	Ø5.165 WAS Ø5.190 ADD PRESSURE TESTING OPTION NEW ISSUE DESCRIPTION	ADD D3262-043/-5 (ZM 95-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN 82-4; C2-4) PER CAR 09-004 Ø5.165 WAS Ø5.190

		DANIACROSIACEI							
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA							
CHECKED	6 5.	DRAWING NO.	REV. E						
MFG. APPR.	9/	D3262	SHEET 1 OF 5						
APPROVED	NP.	TITLE	SCALE						
DE APPR.	-#	FUEL PURGE CANISTER	NTS						
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPAC THIS DOCUMENT IS PRIVATE AND COMPONITION AND IS SUPPLIED DIT THE EXPRES NOT TO BE USED FOR ANY PURPOSE OR COVERD OR COMMUNICATED TO ANY OT	BS CONDITION THAT IT IS						

1 1 D3262-1 TUBE 2 2 D3262-5 CAP		À	U3262-04.	CANISTER ASSEMBLY
2 2 D3262-5 CAP		1	D3262-1	TUSE
	2	2	D3262-5	CAP





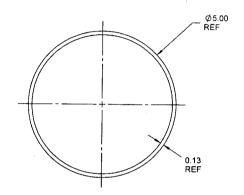


DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	6 5.	DRAWING NO.	REV. E
MFG. APPR.	91	D3262	SHEET 2 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	4	FUEL PURGE CANISTER	NTS
DATE 10.05.03		THE COLUMBIT OF SOME BY DART A EROSPACE L.TD THE COLUMBIT IS PANTA END COMPENHAL MOST SUPPLIED ON THE EXPREST CONDITION THAT IT IS NOT TO BE USED FOR ANY PARYONS OR COMED ON COMMANICATED TO ANY OTHER PERSON WITHOUT WANTED FOR THE CONTINUE FOR COMPENSATION OF THE PERSON WITHOUT WANTED FOR THE CONTINUE FOR COMPENSATION OF THE PERSON WITHOUT WANTED FOR THE CONTINUE FOR COMPENSATION OF THE PERSON WITHOUT WANTED FOR THE CONTINUE FOR COMPENSATION OF THE PERSON WITHOUT WANTED FOR THE CONTINUE FOR COMPENSATION OF THE PERSON WITHOUT WANTED FOR THE CONTINUE FOR COMPENSATION OF THE PERSON WITHOUT WANTED FOR THE CONTINUE FOR	

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NOTES.
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 2.50 lbs
8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

8



D3262-1 TUBE

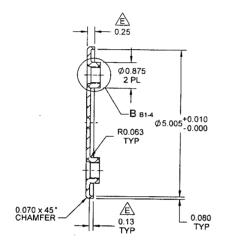


NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6T5.000W.125

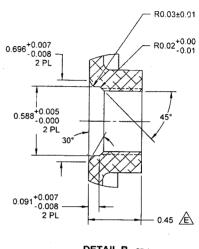
REF. DART SPEC. M60611615.000VV.125
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.96 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE	TD
DRAWN	RF	HAWKESBURY, ONTARIO, CANA	
CHECKED	45	DRAWING NO.	REV. E
MFG. APPR.	9/	D3262	SHEET 3 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	-#	FUEL PURGE CANISTER	NTS
DATE 10.05.03		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT & PRINATE AND COMPRESTING AND IS SUPPLIED ON THE EXPRESS CONCINON THAT IT IS NOT TO ME LIGHT DEFORM FOR COMPRISON OF COMPRISON AND THE STREET WITHOUT OF	

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DRILL THRU Ø0.516 (33/64 DRILL), TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879 Ø5.165 REF 2 PL 1.63 3.25 REF 6



DETAIL B C7-4

SECTION A-A C5-4

D3262-3 CAP

1) MATERIAL: 6061-16/1651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH V 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
7) WEIGHT: 0.28 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

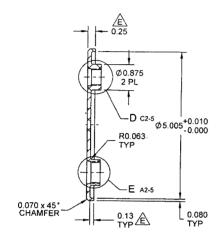
DESIGN	RF	DART AEROSPACE LTD	
DRAWN RF		HAWKESBURY, ONTARIO, CANADA	
CHECKED	\$ 5.	DRAWING NO. REV.	Ε
MFG. APPR.	91	D3262 SHEET 4 OF	5
APPROVED	143	TITLE SCAL	Ε
DE APPR.	-4	FUEL PURGE CANISTER NT	s
DATE 10.05.03		THIS OCCUPIENT OF 2004 BY DART AEROSPACE LTD THIS OCCUPIENT OF PRIVATA WHO CONTRIBUTES UNDER SEPPLIED ON THE EXPRESS CONSTION THAT IT IS HOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMANDATED TO ANY OTHER PERSON WITHOUT	

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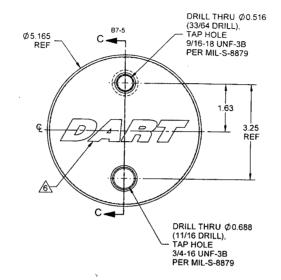
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2



SECTION C-C D5-5

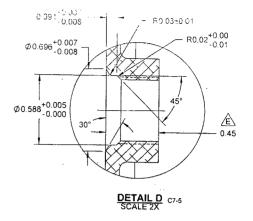


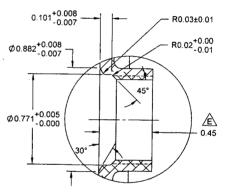
D3262-5 CAP

NOTES: 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6B

REF. DART SPEC. M6061168
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
7) WEIGHT: 0.77 Ibe

7) WEIGHT: 0.27 lbs 8) PART IS SYMMETRICAL ABOUT CENTERLINE





DESIGN	RF	DART AEROSPACE I	TD
DRAWN	RF	HAWKESBURY, ONTARIO, CANA	
CHECKED	15	DRAWING NO.	REV. E
MFG. APPR.	91	D3262	SHEET 5 OF 5
APPROVED	MP.	TITLE	SCALE
DE APPR.	-#	FUEL PURGE CANISTER	NTS
DATE 10.05.03		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED DIN THE EXPRESS CONDITION THAT IT IS NOT THE LIGHT LIFE AND RESIDENCE OF COMMON THAT IT IS	

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